

Date: Monday, 18/08/2008 3:31:40 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 41316A	
Estimate Number : 10148	
P.O. Number :	Part Number : D2161205
This Issue : 18/08/2008 S.O. No. :	Drawing Number : D2161 REV B2
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B2
Previous Run : 36467A	Material :
Written By :	Due Date : 10/09/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JLD 08.8.18</u>	
Comment : Est Rev:A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	41316A01	MIRROR BRACKET LH
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Comment: Sub-Component MIRROR BRACKET LH

1 x D2013-1 Batch

B36950 ✓

Cpl 08.11.24

2.0	41316A02	MIRROR BRACKET RH
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Comment: Sub-Component MIRROR BRACKET RH

1 x D2013-2 Batch

B36938 ✓

Cpl 08.11.24

3.0	41316A03	ARM
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Comment: Sub-Component ARM

1 x D2037-101 Batch

41854 ✓

Cpl 08.11.24

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Assemble on Jig DT8065 as per Dwg D2161

2-Weld as per Dwg D2161 Identify as D2161-205

Cpl 08.11.24

(4)

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

20/11/24 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 41316A

Part Number: D2161205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soslu24 (40)

7.0

POWDER COATING

POWDER COATING



M105642



(4X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-40
320 OF
9-10

M-1 08/11/25

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

88 08/11/25 (40)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26 (40)

Job Completion



mf 08-11-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

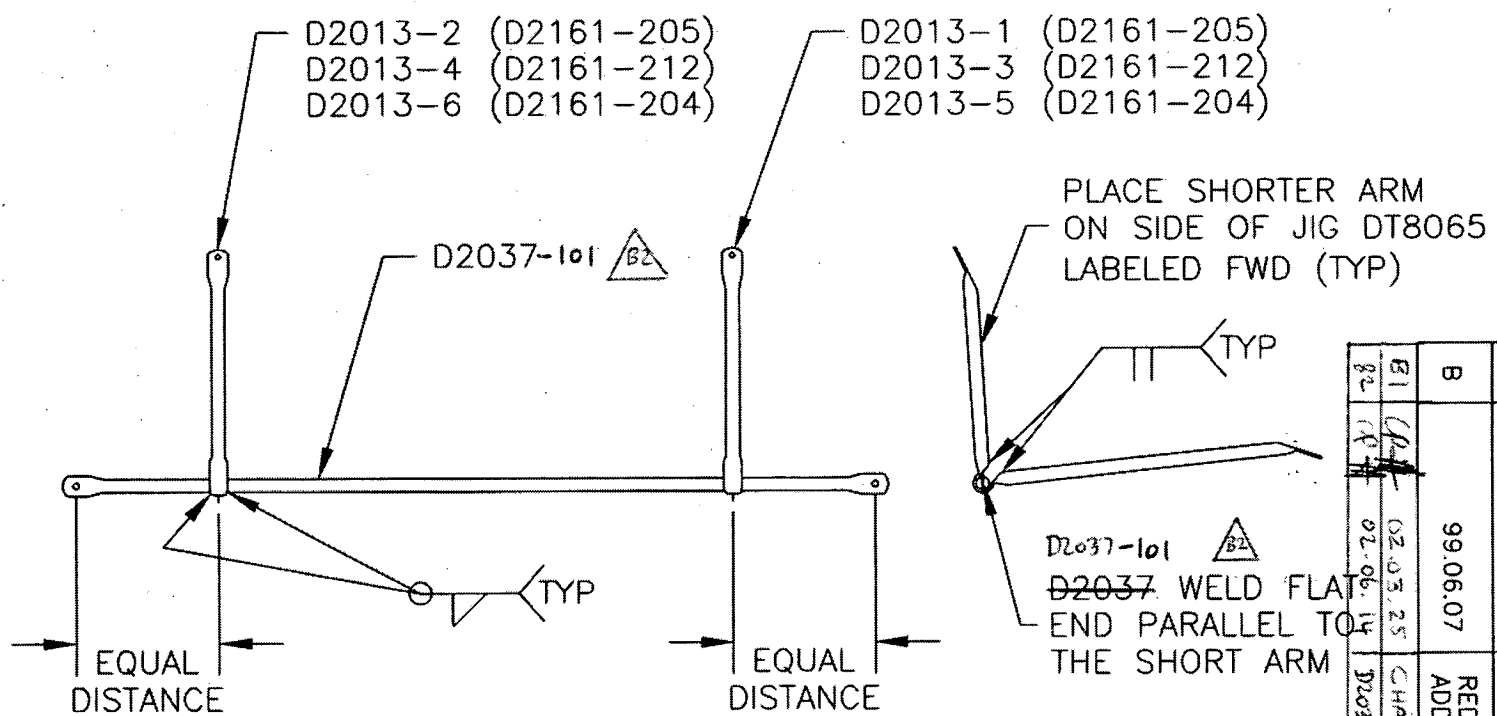
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
JB	RE		
CHECKED KE	APPROVED RE	DRAWING NO. D2161	SHEET 1 OF 1
DATE 99.06.07	TITLE MIRROR BRACKET	SCALE NTS	
A	93.04.29	NEW ISSUE	
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS	
B1 82	02.03.25 02.06.13	CHANGE FINISH D2037-101 W/	

RELEASED
KE 99.06.10



DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

SH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
~~POWDER COAT BLACK SANDTEX (4.3.5.7) PER~~
~~DART QSI 005 4.3~~ (8)

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